84900

Page 1

May-29-12 2:49:39 PM Item ID: D209-669-043 Accept *N900040100* Setup Start Revision ID: Item Name: Replacement Skidtube **Start Date:** Start Qty: 1.00 29/05/2012 **Cust Item ID: Required Date: 16/07/2012** Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: _MLJ Date: 12/05 79 Tooling: Approvals: QC: Date: Sequence ID/ Operation Tool# Plan Reject Reject Accept Insp. **Work Center ID** Description Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D2906 Rev B 100 0.00 DOCUMENT CONTROL *100* DC Memo Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002 for ECN 12-597 Document Control 110 0.00 Skidtubes *110* Skidtubes 0.00 Memo 1206-20 SAO Skidtubes - Inspect mat'l D2500-1-190 for damage -Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid) -Open holes to 0.500" as per Dwg D2906 without cutting fluid -Deburr and blow out all chips from -Acid etch and Alodine tube per QSI 005 4.1

Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER CHANGES									
DATE	STEP		PRO	CEDURE CHANGE	·		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval -	
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Part No	•	3	PAR #:	Fault Category:	1.0		ICR: Yes	No DQ	A :	_ Date: _		

Resolution:			Dispositio	n: <u>' </u>	QA: N/C Clo	sed:	Date: _	
NCR:		W		ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section B Action Description	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspecto
12(06/20	# 100	14th had Dritten b .570 Shows he & Bod" R-C. Drive toward in employ NAND. Operated error Front Front (tooward) of tube # 7 note	Chief Eng	Chief Eng	Date	,	12041	18 poolso
3				4				1

Revision ID:	D209-669-04	•		Accept	*N90	0040	100)* s	Setup Star Stop	10'21
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1: *1:	•	Cust Ite Custom					
Approvals:		n:	Date:	Tooling: SPC (Y/N):		Date:		F	Run Star Stop	"NR1"
Sequence ID/ Work Center ID 120 *120* QC Quality Control		Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
*1304 *130* Skidtubes Skidtubes		Pick: Qty Part Nu A/R Sikafl Sikaflex expii Start Time: Fin Time: pick: Qty	mber Description I		ore cutting					

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DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No: \$\overline{\mathbb{D}29-669-043} \text{ PAR #: _____ Fault Category: _\mathbb{K}10 \tau \text{ TUDE . _____

NCR: Ves No DQA: Date: 1408)

Resolution: Sam

Disposition: Sund

QA: N/C Closed:

NCR: 12	-1691	W	ORK OR	DER NON-CONFORMANCE	(NCR)	\$13	00.85	3
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
12/20/14	100	Foons when always take In horry gush on the Bottom about 85,250 Prom Ath. locks to be at less 0.0600 Deco. (see attract P.c's) It. Packagin Supplier	No.	Scrap + Jestry take. No Replace	7.63	5AD 12-08-14	12/10/14	0AS 166 17/05/14
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Quality Control

Page 3

May-29-12 2:49:39 PM Item ID: D209-669-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 29/05/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 16/07/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: **Approvals: Tooling:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 140 0.00 BENDING MACHINE - CROSSTUBES *140* CNC Bend 1 0.00 Memo CNC Delta 100 Bender 1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT 2-Cut tubes as per Dwg. D2906 0.00 Skidtubes Skidtubes 0.00 Memo Skidtubes -Deburr ends and remove markes from bending - Insert D4202-1 spacer, swage as per QSI002 and trim/grind flush per OSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expantion and finish with 1/2 x 18G to achieve dwg dimention. 160 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo

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		Description of NC		Corrective Action Section	В	Vorifi	cation	Ammuoval	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Approval Chief Eng	Approval QC Inspector
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Revision ID:	D209-669-043			1.5 1.4	Accept	*N90	0040)*	Setup S	Start Stop	*N *N	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Iten Customer							
Approvals:	Process Plan QC:	:					Date:				Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID 170 *170* Skidtubes Skidtubes) <u>1</u>	not to hit we	eb.Deburr soles for aft &	t fwd cap usin	Set Up/ Run Hours 0.00 0.00 17 Open holes to 19/64 g DT8215 open holes 8091-3 , open to .64	to #6" Deburr	Tool#	Plan Code	Accept	t Rejec Qty		Reject Number	Insp. Stamp

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QC5- Inspect part completeness to step on W/O

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Memo

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Quality Control

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Work Ord May-29-12 2:4				*849	900*							Page 5	
Item ID: Revision ID:	D209-669-0	43		Accept	*N90	0040	1100	ገ*	Setup S	Start 🛪	N:	S1*	
Item Name:	Replacement	Skidtube								Stop 🛪	'N!	S2*	
Start Date:	29/05/2012	Start Qty: 1.00	*1*		Cust Iter	m ID:							
Required Date: Reference:	: 16/07/2012	Req'd Qty: 1.00	*1*		Custome	er:							
Approvals:	Process Pla	an:	Date:	Tooling:		Date:					NI	R1*	
	QC:		Date:	SPC (Y/N):		Date:				Stop *	NI	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty	t Reje Nun	ect	Insp. Stamp	
200		Pressure Wash per QSI00	05 4.3	0.00			-			5 -		•	
200 HandFinish Hand Finishing		Memo		0.00									
210		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00									
210 Powdercoat		Memo		0.00				r-reme to.	-				
Powder Coating		START TIM OVEN TEM FINISH TIM	E: PERATURE: E:										
220		QC3- Inspect Part Finish		0.00									
220													
QC		Memo		0.00									

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Quality Control

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		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
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May-29-12 2:49:39 PM

84900

Page 6

Item ID: D209-669-043 Accept *N900040100* Setup Start **Revision ID:** Replacement Skidtube Item Name: Start Qty: 1.00 *1* **Start Date:** 29/05/2012 Cust Item ID: Required Date: 16/07/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Approvals: Tooling: Date: Stop QC: _____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code **Qty** Qty Number Stamp 230 0.00 HandFinishing *230* HandFinish 0.00 Memo Hand Finishing 1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 Sikaflex expire date: 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906 3-Inspect for foreign object per QSI 024 4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 Sikaflex expire date: 5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch:

W/O:			W	ORK ORDER CHANG	ES				*	
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										
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Work Order ID 84900 May-29-12 2:49:39 PM		-	*84900*								Page '	7		
Item ID: Revision ID:	D209-669-0			•	*N900040100* Setup		Start	*N	S1*					
Item Name: Start Date: Required Date: Reference:	Replacement 29/05/2012 16/07/2012	Start Q	ty: 1.00 Pty: 1.00	*1* *1*		Cust Item Customer					Stop	*N.	S2*	
Approvals:	Process Pla	ın:		Date:	Tooling:	··· -	Date:			Run	Start	*N	R1*	
	QC:			Date:	_		Date:				Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re		Reject Number	Insp. Stamp	
240 * 740 * QC Quality Control		QC5- Inspe	Memo Inspect Aft (Cap, Fwd Step and Wicts per QSI 024	0.00 0.00 ng Walk of work to Current	Step Inspect for								
250 *250* Packaging Packaging		Packaging	Memo Identify and Location: PPP Rev:		0.00 0.00 per PPPD209-669-043									
²⁶⁰		QC21- Fina	al Inspection -	Work Order Release	0.00									

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Quality Control

MCJ 12/08/14 closed at Zeno

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May-29-12 2:49:44 PM

Work Order ID: 84900

D209-669-043

84900

D209-669-043

Parent Item:

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	•	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No				Each	81.0000		19			
D4202-1									**				- · <u></u>
				Location	<u>on</u>	Loc	<u>Qty</u>	Loc Code					
				LG			5						
					77727		5						
				LG002			76		_				
					78806		6						
D2500-1-190					79810		70						
		Manufactured	No			110	Each	91.0000	1	1			
D2500-1-1 Ext'n - I' Beam Tube 4"	190								**	SA	Ŋ	12	06.10
				Locatio	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				HALL			91		****				
					74777		14						
D2926-3			N 1		80061		77		_	<u> </u>			
		Manufactured	No			110	Each	0.0000	1	1			
D2926-3									** 				
D2855		Manufactured	No			230	Each	21.0000	2	2			
D2855									**	-			
Cap									-				
				<u>Locatio</u>	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				FP002			21						
					65519		2		_				
					73347		16						
					75074		3		_				

		7							
W/O:			WC	ORK ORDER CHANGE	ES				,
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May-29-12 2:49:44 PM

Work Order ID: 84900

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

84900

D209-669-043

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 2

Start Qty: 1.00

Required Qty: 1.00

Purchased No 230 Each

**

1,090.000

AN3-5A

AN3-5A

<u>Location</u>	<u>Lo</u>	c Oty	<u>Loc Code</u>			
ST350		1090				
115371		46				
117423		124				
118626		31			-	
119355		200				
120187		500				
121185		189				
	230	Each	0.0000	4	4	
			*	*		
	230	Each	2,136.000	44	44	

**

NAS1149D0332J Purchased *AN960.ID101 *

Washer

ALS7-1032-130

AN960JD10L

No

No

Purchased

AI S7-1032-130

Location		Loc Oty	Loc Code	
ST280		51		
	117717	27		
	118966	22		
	119775	2		
ST282		2085		
	119530	73		
	120181	12		
	121444	2000		

									
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Work Order ID: 84900

D209-669-043

Parent Item Name: Replacement Skidtube

NAS1149C0332

84900 *D209-669-043*

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 3

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Parent Item:

Purchased

Purchased

No

No

230

Each

1,458.000

44

**

AN3C4A

Location	Lo	c Oty	Loc Code			
ST350		1458				
120187		57				
120521		28				
120769		38				
121205		1000				
121556		335				
	230	Each	0.0000	44	44	
				**		

*AN960C101 *

washer

AN960C10L

D2594-3

Manufactured No 230

Each

2,418.000

14

14

D2594-3 O-Ring, 205 Skidtube

<u>Location</u>	Loc Oty
FP001	2418
65518	41
79496	984
79573	50
79755	1343

Loc Code

**

Shop Packet Print

W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval CO Inspector
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		Section A	Chief Eng	Action Description Chief Eng	Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print May-29-12 2:49:44 PM				-						Page
Work Order ID: 84900 Parent Item: D209-669-043 Parent Item Name: Replacement	Skidtube		4900 1209	n* -669-6	N43*			tart Date: 2 Start Qty: 1		Required Date: 16/07/2012 Required Qty: 1.00
D2594-1	Manufactured	No			230	Each	311.0000	14	14	
D2594-1 Plug, 205 Skidtube								**	=	·
			Location	<u>on</u>	<u>L</u>	oc Qty	Loc Code			
			FP001			98				
				73401		30				
				74442 79495		18				_
			FP-A	13433		50				_
			11-24	73401		213 0				******
				78590		213				
D3564-9	Manufactured	No			230	Each	22.0000	1	1	
D3564-9								**		
			Locatio	<u>on</u>	<u>L</u> c	oc Qty	Loc Code			
			FG			4				
				76950		4				<u> </u>
			FP001			18				
				67590 69943		4				
				82255		13				_
D3564-11	Manufactured	No		02200	230	Each	8.0000	1	1	_
D3564-11								**		

May-29-12 2:49:44 PM

Loc Qty

Loc Code

Location

77056

80341

FG

FP001

Page 4

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Picklist Print

May-29-12 2:49:44 PM

Work Order ID: 84900

D209-669-043

Parent Item Name: Replacement Skidtube

Parent Item:

84900

D209-669-043

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Page 5

D3564-5

D3564-5

Manufactured No

Manufactured

Manufactured

No

230

Each

13.0000

**

Location Loc Qty Loc Code FG 2 2 34806 FP001 11 77609 3 82254 8 230 Each 31.0000 2 **

D3566-1

Gasket

D3566-1

Location		<u>Lo</u>	c Qty	Loc Code	
FP			-22		
	81619		10		
FP002			53		
	68924		2		
	80919		3		
	83898		16		
		230	Each	21.0000	1

D3566-5

D3566-5

Gasket

Location Loc Qty Loc Code FP 12 82275 12 FP002 9 80374 3 82274

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May-29-12 2:49:44 PM

Shop Packet Print

Page 5

W/O:			WO	RK ORDER CHANGI	ES		· · · · · · · · · · · · · · · · · · ·		
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	eation	Approval	Approval
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Description	SKIDTUBE ASSEMBLY	SKIDTUBE ASSEMBLY		EXTRUSION	CROSS BOLT SPACER	PLUG	O-RING	AFT CAP	WEB	WEB	WEARSHOE (REPLACES D2577-1)	WEARSHOE (REPLACES D2577-3)	WEARSHOE (REPLACES D2577-5)	WEARSHOE	GASKET	GASKET	GASKET	INSERT			BOLT	BOLT	WASHER	WASHER
Part Number	D2906-041	D2906-043		D2500-1-190	D2579	D2594-1	D2594-3	D2855	D2926-1	D2926-3	D3564-9	D3564-11	D3564-5	D3564-15	D3566-1	D3566-5	D3566-15	ALS7-1032-130	or AKS4-1032-130	or ALS4-1032-130	AN3C4A	AN3-5A	AN960C10L	AN960JD10L
QTY -043		×		Ļ	19	14	14	2		1	1	1			2	1		44	•		44	4	44	4
QTY -041	×			1	22	12	12	2	1		1	1	1	1	2	1	-	90	-		20	4	20	4
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GENERAL NOTES

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 0. <u>84900 M</u>L

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- S)
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
 3) INSERT D2926-11-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND OF SKIDTUBE AND SHOWN OFF AFT END OF SKIDTUBE AND OF SKIDTUBE AND SHOWD WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241291

 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 6) USE DART DRILL TEMPLATE D72906-04117 (D2906-043)
 TO LOCATE AND DRILL Z00.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3CAA BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
 7) WELDING TO BE DONE PER DART QSI 004. 6

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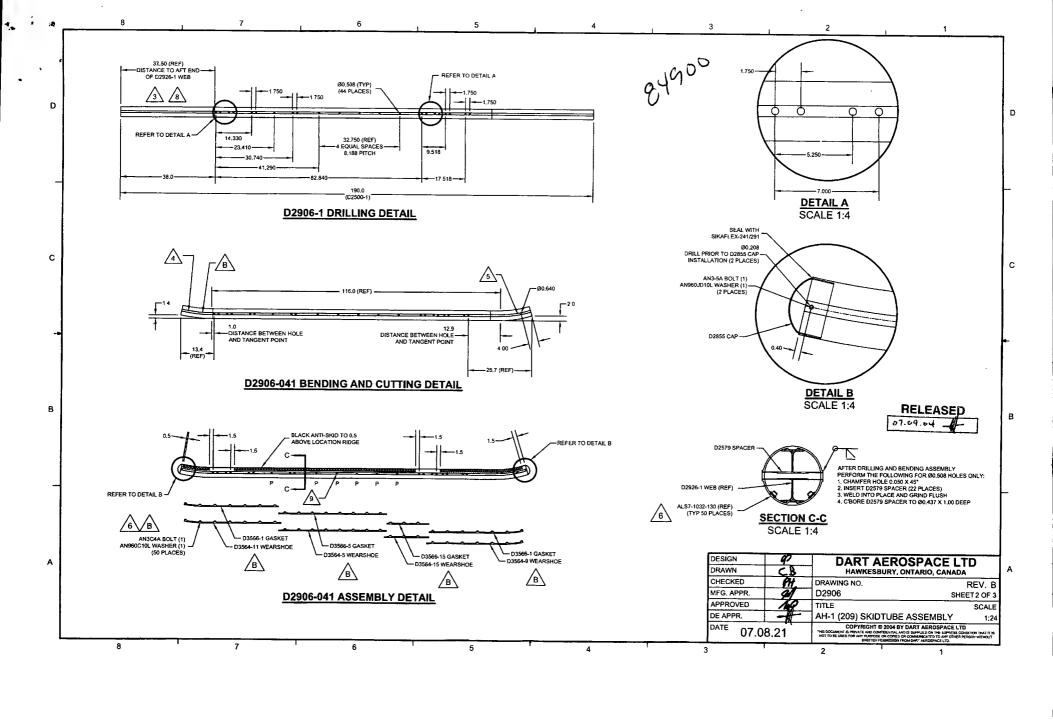
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

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NTS	:MBLY	AH-1 (209) SKIDTUBE ASSEMBLY	1	نہ	DE APPR.
SCALE		TITLE	100	ÆD	APPROVED
SHEET 1 OF 3	S	D2906	gs/	PR.	MFG. APPR.
REV. B		DRAWING NO.	£	Ω	CHECKED
i Ą	O, CANA	HAWKESBURY, ONTARIO, CANADA	CB		DRAWN
Η -	ACF	DART AFROSPACE I TO	cb		DESIGN
DATE	β	DESCRIPTION	О		REV.
04.06.22	g		SSUE	NEW ISSUE	۷
		PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	3: CORRECTE 7: 38 PLACES	PG 3 C	
07.08.21	8	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;	PG 2 C7: REMOVE AF	PG 20	0
		CHANGE WEARPLATE HARDWARE TO SS;	3E WEARPLAT	CHAN	
		ADD STAINLESS STEEL WEARPLATES AND GASKETS	TAINLESS STE	ADD S	_
		UPDATE DRAWING FORMAT: RE-ORGANIZE:	E DRAWING F	UPDA	

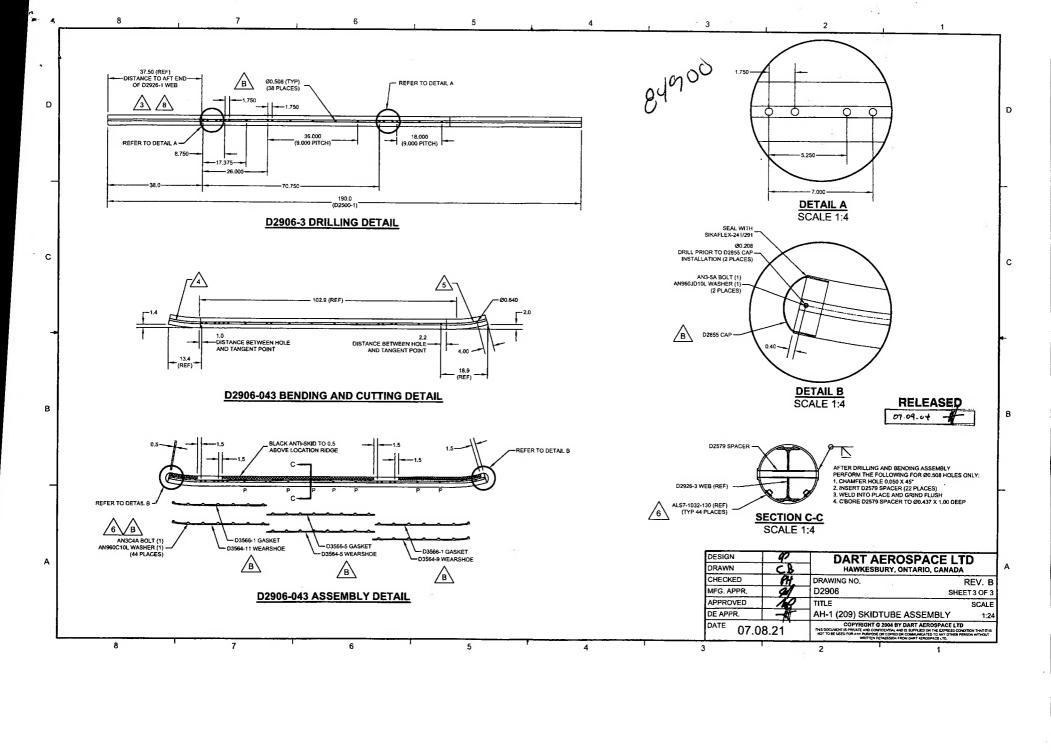
Dart Aerospace L	_td
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W/O:			WC	ORK ORDER CHANG	BES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C (closed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Dart Aeros	pace Ltd
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W/O:			W	ORK ORDER CHANGE	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositi	on:	QA: N/C Cld	sed:	Date: _	
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
<u>.</u>								
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Dart Aerospace Ltd	
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			Disposition: QA							
NCR:		W	ORK OR	DER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B				Verific	Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	•	Sign & Date	Section		Chief Eng	QC Inspector
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